

SHIP July 13

Work Order ID 134133

134133

Page 1

Item ID: D350-689-031

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Armrest / Control Guard Retrofit

Start Date: 7/3/2015 Start Qty: 2.00

Required Date: 7/3/2015 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLS Date: JUL 03 2015

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D350-689

C

J.A

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy D350-689 bluefile & type labels per PPP D350-689-031 CHG002

DAS

02

9-89

SEP 24 2015

101

Pick Kit

0.00

101

Packaging

Memo

0.00

Packaging

DAS

27

9-89

JUL 08 2015

DAS

02

9-89

JUL 08 2015

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

DAS

02

9-89

SEP 24 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

Work Order ID 134133

Friday, July 03, 2015 11:37:14 AM

134133

Page 2

Item ID: D350-689-031

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Armrest / Control Guard Retrofit

Stop ***NS2***Start Date: 7/3/2015 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 7/3/2015 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-689-013 Location: _____ PPP Rev: _____								SEP 24 2015
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

SEP 24 2015

MCS

SH 20150924

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

Picklist Print

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Page 1

Work Order ID: 134133

134133

Parent Item: D350-689-031

D350-689-031

Parent Item Name: Armrest / Control Guard Retrofit

Start Date: 7/3/2015

Required Date: 7/3/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 12.07.06 new issue EC verified by:DD
15.02.11 AS PER ECN 15-520 DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2199-31 *D2199-31* Strut Details		Manufactured	No			101	Each	2.0000	1	2		DAS 27 9-89	DAS 6 9-89
	DAS 02 9-89								**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST351				2		B133409	2		
				129757				2					
D4671-1 *D4671-1* Armrest Cushion		Manufactured	No			101	Each	8.0000	1	2		DAS 27 9-89	DAS 6 9-89
	DAS 02 9-89								**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST223a				8			2		
				128357				8					
D5159-041 *D5159-041* Seat Back Brace Assembly		Manufactured	No			101	Each	11.0000	1	2		DAS 27 9-89	DAS 6 9-89
	DAS 02 9-89								**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST506				11					
				133517				1					
				134073				10					
D5159-043 *D5159-043* Seat Back Brace Assembly		Manufactured	No			101	Each	11.0000	1	2		DAS 27 9-89	DAS 6 9-89
	DAS 02 9-89								**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST506				11					
				133461				1					
				134074				10					
				134075									

JUL 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :									
Misidentified ☐	Past Due ☐										

Picklist Print

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Page 2

Work Order ID: 134133

134133

Parent Item: D350-689-031

D350-689-031

Parent Item Name: Armrest / Control Guard Retrofit

Start Date: 7/3/2015

Required Date: 7/3/2015

Start Qty: 2.00

Required Qty: 2.00

D5159-045

Manufactured No

101

Each

3.0000

1

2

DAS
27
9-89

D5159-045

Seat Rib Assembly

DAS
02
9-89

Location

Loc Qty

Loc Code

ST228

3

129550

3

B134536

21

D5189-041

Manufactured No

101

Each

0.0000

1

2

**

134134 Sm

D5189-041

Tube Assembly

DAS
02
9-89

D5189-043

Manufactured No

101

Each

0.0000

1

2

**

DAS
27
9-89

D5189-043

Armrest Assembly

DAS
02
9-89

AN4-4A

Purchased No

101

Each

386.0000

1

2

**

DAS
27
9-89

AN4-4A

BOLT

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001

24

m125709

24

ST325A

362

m129390

362

JUL 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

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Work Order ID: 134133

134133

Parent Item: D350-689-031

D350-689-031

Parent Item Name: Armrest / Control Guard Retrofit

Start Date: 7/3/2015

Required Date: 7/3/2015

Start Qty: 2.00

Required Qty: 2.00

AN4-6A

Purchased

No

101

Each

1,170.000

1

2

AN4-6A

BOLT

DAS
02
9-89

**

DAS
27
9-89



Location

Loc Qty

Loc Code

CA

143

M128403

43

M130851

100

ST325A

1019

9231

12

M131153

1007

ST345

8

M128403

8

AN4-10A

Purchased

No

101

Each

85.0000

1

2

AN4-10A

Bolt

DAS
02
9-89

**

DAS
27
9-89

JUL 08 2015



Location

Loc Qty

Loc Code

CA

17

M129682

17

ST345

68

131677

62

M130466

1

M131153

5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Picklist Print

Friday, July 03, 2015 11:37:18 AM

Page 4

Work Order ID: 134133

134133

Parent Item: D350-689-031

D350-689-031

Parent Item Name: Armrest / Control Guard Retrofit

Start Date: 7/3/2015

Required Date: 7/3/2015

Start Qty: 2.00

Required Qty: 2.00

AN4-14A

Purchased

No

101

Each

407.0000

2

4

AN4-14A

Bolt

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

5

122141

5

ST325A

376

131677

2

M131153

5

M132317

169

M132640

200

ST344

26

M130716

15

M131803

11

**

DAS
27
9-89

DAS
9-89

AN4-17A

Purchased

No

101

Each

120.0000

1

2

AN4-17A

Bolt

DAS
02
9-89

Location

Loc Qty

Loc Code

ST325A

96

M131800

96

ST343

24

M126105

24

**

DAS
27
9-89

DAS
9-89

AN970-4

Purchased

No

101

Each

341.0000

1

2

AN970-4

Washer

DAS
02
9-89

Location

Loc Qty

Loc Code

ST329

341

4087

1

m129521

340

**

DAS
27

JUL 08 2015

DAS
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER :			
Misidentified ☐	☐	Past Due ☐	☐				

Picklist Print

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Page 5

Work Order ID: 134133

Parent Item: D350-689-031

Parent Item Name: Armrest / Control Guard Retrofit

134133

D350-689-031

Start Date: 7/3/2015

Required Date: 7/3/2015

Start Qty: 2.00

Required Qty: 2.00

MS20600-AD4W4

Purchased

No

101

Each

1,340.000

4

8

MS20600-AD4W4

Rivets

DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST308

506

M128899

6

M132640

500

WA003

834

M132256

834

MS20600-AD4W5

Purchased

No

101

Each

546.0000

8

16

MS20600-AD4W5

Blind Rivet

DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

CCK004

200

m131618

200

ST308

346

m129820

19

m131340

27

m132640

300

JUL 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

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Work Order ID: 134133

Parent Item: D350-689-031

Parent Item Name: Armrest / Control Guard Retrofit

134133

D350-689-031

Start Date: 7/3/2015

Required Date: 7/3/2015

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

101

Each

1,618.000

10

20

MS21042L3

Nut

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001

393

M130922

393

GA

440

M131317

440

ST305

785

116549

12

126333

49

M128754

2

M132123

17

M132382

705

**

DAS

27

9-89

DAS
02
9-89

MS21042L4

Purchased

No

101

Each

4,288.000

8

16

MS21042L4

Locknut

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

150

m127813

150

ST260a

3956

m130799

56

m131803

6

m132262

894

m132382

3000

ST305

180

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

**

DAS

27

JUL 03 2015

DAS
02
9-89

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Page 6

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

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Page 7

Work Order ID: 134133

Parent Item: D350-689-031

Parent Item Name: Armrest / Control Guard Retrofit

134133

D350-689-031

Start Date: 7/3/2015

Required Date: 7/3/2015

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-17

Purchased

No

101

Each

291.0000

1

2

MS27039-1-17

Screw (601.1954)

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

188

120142

38

m127831

150

ST285

103

m127305

100

m130388

3

**

DAS
27
9-89

DAS
6
9-89

MS27039-1-18

Purchased

No

101

Each

1,896.000

3

6

MS27039-1-18

Screw

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

273

123522

73

124326

200

ST273A

1373

124326

1373

ST284

250

124326

250

**

DAS
27
9-89

DAS
6
9-89

MS27039-1-19

Purchased

No

101

Each

304.0000

4

8

MS27039-1-19

Screw

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

128

m124326

32

m127904

96

ST273A

157

m127904

157

ST284

19

m127904

19

**

DAS
27
9-89

DAS
6
9-89

JUL 08 2015

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Work Order ID: 134133

Parent Item: D350-689-031

Parent Item Name: Armrest / Control Guard Retrofit

134133

D350-689-031

Start Date: 7/3/2015

Required Date: 7/3/2015

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-20

Purchased

No

101

Each

240.0000

2

4

MS27039-1-20

Screw

DAS
02
9-89

**

DAS
27
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST284

240

124326

240

MS27039-4-20

Purchased

No

101

Each

106.0000

4

8

MS27039-4-20

Screw

DAS
02
9-89

**

DAS
27
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST273A

100

m132551

100

ST283

6

m130835

6

MS27039-4-22

Purchased

No

101

Each

36.0000

2

4

MS27039-4-22

Screw

DAS
02
9-89

**

DAS
27
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST284

36

m131616

36

MS27039-4-21

Purchased

No

101

Each

32.0000

4

8

MS27039-4-21

Screw

DAS
02
9-89

**

DAS
27
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST284

32

m129909

18

m131616

14

JUL 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : ☐			

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Work Order ID: 134133

Parent Item: D350-689-031

Parent Item Name: Armrest / Control Guard Retrofit

134133

D350-689-031

Start Date: 7/3/2015

Required Date: 7/3/2015

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0332J

Purchased

No

101

Each

1,277.000

20

40

NAS1149D0332.J

Washer

DAS
02
9-89

Location

Loc Qty

Loc Code

CA

14

m129682

14

ST269

1010

m130325

930

m131624

80

ST270

253

m132189

253

**

DAS
27
9-89

DAS
02
9-89

NAS1149D0432J

Purchased

No

101

Each

809.0000

17

34

NAS1149D0432.J

WASHER

DAS
02
9-89

Location

Loc Qty

Loc Code

ST269

809

m131026

809

**

DAS
27
9-89

DAS
02
9-89

NAS43DD4-16FC

Purchased

No

101

Each

32.0000

2

4

NAS43DD4-16FC

Spacer

DAS
02
9-89

Location

Loc Qty

Loc Code

ST262

32

m130835

32

**

DAS
27
9-89
JUL 08 2015

DAS
02
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

6.0 PARTS LIST (OPTIONAL KITS)

Qty -015	Qty -017	Qty -031	Part Number	Description
X			D350-689-015	SEAT MODIFICATION KIT
	X		D350-689-017	SHOULDER HARNESS KIT
		X	D350-689-031	ARMREST KIT
		1	D2199-31	STRUT
2			D3029-1	SPRING
2			D3030-1	LOCK
1			D3033-1	SEAT TRACK
4			D3059-1	STUD
4			D3060-1	BUSHING
4			D3061-1	RADIUS BLOCK
	2		D4071-041	SHOULDER HARNESS ASSY
		1	D4671-1	ARMREST CUSHION
		1	D5159-041	SEAT BACK BRACE ASSY
		1	D5159-043	SEAT BACK BRACE ASSY
		1	D5159-045	SEAT RIB ASSY
		1	D5189-041	TUBE ASSY
		1	D5189-043	ARMREST ASSY
			AN3-12A	BOLT
		1	AN4-4A	BOLT
		1	AN4-6A	BOLT
		1	AN4-10A	BOLT
		2	AN4-14A	BOLT
		1	AN4-17A	BOLT
	2		AN5-4A	BOLT
		1	AN970-4	WASHER
		4	MS20600AD4W4	BLIND RIVET
		8	MS20600AD4W5	BLIND RIVET
		10	MS21042L3	NUT (OR MS21042-3)
		8	MS21042L4	NUT (OR MS21042-4)
4	2		MS21042L5	NUT (OR MS21042-5)
4			MS21059L3	NUTPLATE
1			MS24693-S273	SCREW
3			MS27039-1-10	SCREW
		1	MS27039-1-17	SCREW
		3	MS27039-1-18	SCREW
		4	MS27039-1-19	SCREW
		2	MS27039-1-20	SCREW
		4	MS27039-4-20	SCREW
		2	MS27039-4-22	SCREW
		4	MS27039-4-21	SCREW
		20	NAS1149D0332J	WASHER (OR AN960JD10L)
		17	NAS1149D0432J	WASHER (OR AN960JD416)
	4		NAS1149D0516J	WASHER (OR AN960JD516L)
4			NAS1149D0563J	WASHER (OR AN960JD516)
		2	NAS43DD4-16FC	SPACER